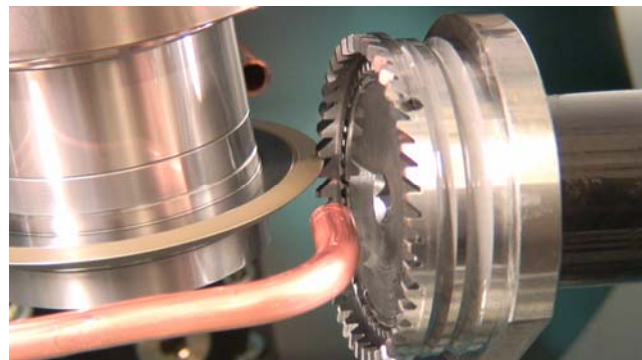






## Denti di Lupo

A40-900

Il particolare lavorato è un ingranaggio del motore di un aereo. Vengono affilati i denti frontali chiamati denti di lupo. Per mezzo dell'abrigher CNC la mola è profilata con due angoli ben precisi secondo un profilo dxf.



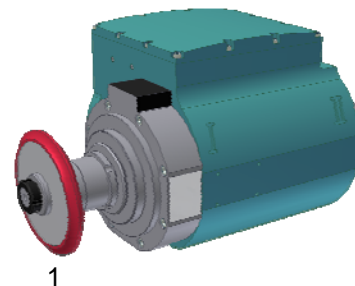
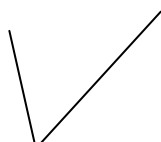
### 1. Cycletime for Production

Specifications Diameter 130 mm, Z5			
Operations			
Feed [mm/Min]	2000	150	150
Power [kW]		1	1
Cutting feed [m/s]		32	24
Used wheels			 1
Grinding time [s]	20	120	360
Total cycle time	8 Min 20		

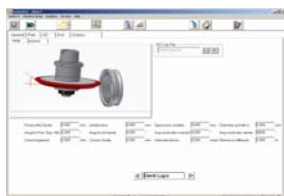
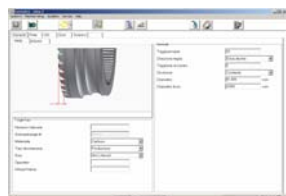
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1 Ø36 DXF Conventional



### 3. Machine and Software Requirements



Machines: 5 axes CNC grinders : NORMA CFG  
 Control: Fanuc 160i  
 Coolant: Synthetic Oil, pressure 6 - 7 bar  
 Software: Quinto 5, DXQ  
 Engineer: Di, 01.04.2009

[www.schneeberger.ch](http://www.schneeberger.ch)

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